



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
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**D4775-041**  
**Job Sheet 202647**



**Part No:** D4775-041

**Job Qty:** 4 pcs

**Part Name:** Strut Assembly



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 10/31/19

**Job Tracking No:**

**Due Date:** 11/26/19

**Created By:** Marie Lajeunesse

**Type:** Stock

**Description:**

**Note:** DWG REV C SHEET 1 IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.08.26 PB1 DD  
VERF:JLM IPP REV:C 13.09.26 AS PER REV.B DD VERF:JLM IPP REV:D 14.01.10 AS PER REV.C DD  
VERF:JLM

**Ship Via:**

### Bill of Materials

### Job Routing

| Op<br>No | Operation              | Qty   | Start Date | Due<br>Date | Standard     |            | Workcenter/Supplier   |           | Sign-off |
|----------|------------------------|-------|------------|-------------|--------------|------------|-----------------------|-----------|----------|
|          |                        |       |            |             | Setup<br>Hrs | Run<br>Hrs | Workcenter / Supplier | Lead Time |          |
| 110      | Packaging 1 - Pick Kit | 4 pcs |            | 11/26/19    | 0.00         | 0.00       | Packaging 1 - 1       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 2       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 3       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 4       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 5       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 6       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 7       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 8       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 9       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 10      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 11      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 12      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 13      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 14      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 15      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 16      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 17      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 18      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 19      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 20      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 21      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 22      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 23      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 24      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 25      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 26      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 27      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 28      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 29      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 30      |           |          |

NOV 13 2019



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**Container No:** S231547



**Part:** D4775-041

**Job No:** 202647

**Serial No/Batch:** S231547

**Revision:**

**Inspector:**

**Exp Date:**

**Instructions:** Various STC's

Date: 11/13/19

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|     |                                     |       |          |           |                         |             |
|-----|-------------------------------------|-------|----------|-----------|-------------------------|-------------|
|     |                                     |       |          |           | Packaging 1 - 31        |             |
|     |                                     |       |          |           | Packaging 1 - 32        |             |
|     |                                     |       |          |           | Packaging 1 - 33        |             |
|     |                                     |       |          |           | Packaging 1 - 34        |             |
|     |                                     |       |          |           | Packaging 1 - 35        |             |
|     |                                     |       |          |           | Packaging 1 - 36        |             |
| 120 | Small Fab - 2 - B4B                 | 4 pcs | 11/26/19 | 0.00 1.66 | Small Fab - 1 - B4B     |             |
|     |                                     |       |          |           | Small Fab - 2 - B4B     |             |
|     |                                     |       |          |           | Small Fab - 3 - B4B     |             |
|     |                                     |       |          |           | Small Fab - 4 - B4B     | NOV 14 2019 |
|     |                                     |       |          |           | Small Fab - 5 - B4B     |             |
|     |                                     |       |          |           | Small Fab - 6 - B4B     |             |
|     |                                     |       |          |           | Small Fab - 7 - B4B     |             |
|     |                                     |       |          |           | Small Fab - 8 - B4B     |             |
|     |                                     |       |          |           | Small Fab - 9 - B4B     |             |
| 130 | QC 5                                | 4 pcs | 11/26/19 | 0.00 0.00 | QC 5 - 10               |             |
|     |                                     |       |          |           | QC 5 - 12               |             |
|     |                                     |       |          |           | QC 5 - 17               |             |
|     |                                     |       |          |           | QC 5 - 18               |             |
|     |                                     |       |          |           | QC 5 - 19               |             |
|     |                                     |       |          |           | QC 5 - 22               |             |
|     |                                     |       |          |           | QC 5 - 24               |             |
|     |                                     |       |          |           | QC 5 - 3                |             |
|     |                                     |       |          |           | QC 5 - 43               |             |
|     |                                     |       |          |           | QC 5 - 49               |             |
|     |                                     |       |          |           | QC 5 - 51               |             |
|     |                                     |       |          |           | QC 5 - 58               |             |
|     |                                     |       |          |           | QC 5 - 68               |             |
|     |                                     |       |          |           | QC 5 - 9                |             |
|     |                                     |       |          |           | QC 5 - 50               |             |
|     |                                     |       |          |           | QC 5 - 30               |             |
|     |                                     |       |          |           | QC 5 - 40               | NOV 20 2019 |
|     |                                     |       |          |           | QC 5 - 61               |             |
|     |                                     |       |          |           | QC 5 - 81               |             |
| 140 | Packaging 3-1 - Stock - B4B 4 pcs ✓ |       | 11/26/19 | 0.00 0.00 | Packaging 3 - 1 - B4B   |             |
|     |                                     |       |          |           | Packaging 3 - 2 - B4B   |             |
|     |                                     |       |          |           | Packaging 3 - 3 - B4B ✓ | ST357       |
|     |                                     |       |          |           | Packaging 3 - 4 - B4B   |             |
|     |                                     |       |          |           | Packaging 3 - 5 - B4B   |             |
|     |                                     |       |          |           | Packaging 3 - 6 - B4B   |             |
|     |                                     |       |          |           | Packaging 3 - 7 - B4B   |             |
|     |                                     |       |          |           | Packaging 3 - 8 - B4B   |             |
|     |                                     |       |          |           | Packaging 3 - 9 - B4B   |             |
|     |                                     |       |          |           | Packaging 3 - 10 - B4B  |             |
|     |                                     |       |          |           | Packaging 3 - 11 - B4B  |             |
|     |                                     |       |          |           | Packaging 3 - 12 - B4B  |             |
|     |                                     |       |          |           | Packaging 3 - 13 - B4B  |             |
|     |                                     |       |          |           | Packaging 3 - 14 - B4B  |             |
|     |                                     |       |          |           | Packaging 3 - 15 - B4B  |             |
|     |                                     |       |          |           | Packaging 3 - 16 - B4B  |             |
|     |                                     |       |          |           | Packaging 3 - 17 - B4B  |             |
|     |                                     |       |          |           | Packaging 3 - 18 - B4B  |             |
|     |                                     |       |          |           | Packaging 3 - 19 - B4B  |             |
|     |                                     |       |          |           | Packaging 3 - 20 - B4B  |             |
|     |                                     |       |          |           | Packaging 3 - 21 - B4B  |             |
|     |                                     |       |          |           | Packaging 3 - 22 - B4B  |             |
|     |                                     |       |          |           | Packaging 3 - 23 - B4B  |             |
|     |                                     |       |          |           | Packaging 3 - 24 - B4B  |             |
|     |                                     |       |          |           | Packaging 3 - 25 - B4B  |             |
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Oscar

NOV 21 2019

DAS  
40  
9-89

NOV 20 2019

ST 357

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|                |       |          |           | Packaging 3 - 26 - B4B |   |
|                |       |          |           | Packaging 3 - 27 - B4B |   |
|                |       |          |           | Packaging 3 - 28 - B4B |   |
|                |       |          |           | Packaging 3 - 29 - B4B |   |
|                |       |          |           | Packaging 3 - 30 - B4B |   |
|                |       |          |           | Packaging 3 - 31 - B4B |   |
|                |       |          |           | Packaging 3 - 32 - B4B |   |
|                |       |          |           | Packaging 3 - 33 - B4B |   |
|                |       |          |           | Packaging 3 - 34 - B4B |   |
|                |       |          |           | Packaging 3 - 35 - B4B |   |
|                |       |          |           | Packaging 3 - 36 - B4B |   |
| 150 QC 21 - SA | 4 pcs | 11/26/19 | 0.00 0.00 | QC 21 - SA - 21        | ✓ |
|                |       |          |           | QC 21 - SA - 70        |   |
|                |       |          |           | QC 21 - SA - 53        |   |

ST357

DAS

21

9-55

NOV 21 2019

## Part Op 110 - (Pick Kit)

Descriptions: 120 - (Small Fab) 1- APPLY PROSEAL ON D4776-1 STRUT AND ASSEMBLE AS PER DWG A/R PROSEAL  
 BATCH: S229888 2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)

op: 620

130 - (QC5- Inspect part completeness to step on W/O)

140 - (Identify as per dwg &amp; Stock Location: \_\_\_\_\_)

150 - (QC21- Final Inspection - Work Order Release)

## Job BOM

| Part / Item  | Component Name      | Quantity      | Operation                  | Container         |
|--------------|---------------------|---------------|----------------------------|-------------------|
| AN3-10A      | BOLT                | 8 Ea (2 ea)   | 110-Packaging 1 - Pick Kit | 912401-2x9220 768 |
| D4775-1      | Strut Tube          | 4 pcs (1 ea)  | 110-Packaging 1 - Pick Kit | 8219611           |
| D4776-1      | Basket Strut Clevis | 4 pcs (1 ea)  | 110-Packaging 1 - Pick Kit | 9210107           |
| D4776-5      | Spacer              | 16 pcs (4 ea) | 110-Packaging 1 - Pick Kit | 8219163           |
| D4777-1      | Rod End Bearing     | 4 pcs (1 ea)  | 110-Packaging 1 - Pick Kit | 8163917           |
| MS21042L3    | Nut                 | 8 Ea (2 ea)   | 110-Packaging 1 - Pick Kit | 8218152           |
| MS21209-F615 | Heli-Coil           | 4 Ea (1 ea)   | 110-Packaging 1 - Pick Kit | 8225389           |

## Job Allocations

| Operation                  | Component Part | Required | Inventory | Allocated |
|----------------------------|----------------|----------|-----------|-----------|
| 110-Packaging 1 - Pick Kit | AN3-10A        | 8        | 141       | 0         |
|                            | D4775-1        | 4        | 41        | 0         |
|                            | D4776-1        | 4        | 63        | 0         |
|                            | D4776-5        | 16       | 72        | 0         |
|                            | D4777-1        | 4        | 23        | 0         |
|                            | MS21042L3      | 8        | 2,621     | 0         |
|                            | MS21209-F615   | 4        | 113       | 0         |

## Part Specifications

Specifications could not be found.

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

| DISPOSITION                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                         | DEPARTMENT/PROCESS                                                                                                                                                                                                                                                                                                     |                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Job: _____                                                                                                                                                                                                                                                                                                                                                                   | Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | Skid-tube <input type="checkbox"/><br>Machining <input type="checkbox"/><br>Large Fab <input type="checkbox"/>                                                                                                                                                                                                         | Cross tube <input type="checkbox"/><br>Small Fab <input type="checkbox"/><br>Finishing <input type="checkbox"/>                                                                                                                                                                                                              | Eng. (Non-AW) <input type="checkbox"/><br>Prod. Eng. Coord. <input type="checkbox"/><br>Rec/Store/Packaging <input type="checkbox"/>                                                                                                                                                                   | Engineering <input type="checkbox"/><br>Water Jet <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Quality <input type="checkbox"/>                                                                                              |
| Date: _____                                                                                                                                                                                                                                                                                                                                                                  | Sequence #: _____                                                                                       | QTY Affected: _____                                                                                                                                                                                                                                                                                                    |                                                                                                                                                                                                                                                                                                                              | MRB (QS1042) _____                                                                                                                                                                                                                                                                                     |                                                                                                                                                                                                                                                  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                             |                                                                                                         | Disposition                                                                                                                                                                                                                                                                                                            |                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                  |
| Root Cause<br>Operator <input type="checkbox"/><br>Manufacturing Process <input type="checkbox"/><br>Equip/Tooling <input type="checkbox"/><br>Handling/Preservation <input type="checkbox"/><br>Material <input type="checkbox"/><br>Product Improvement <input type="checkbox"/><br>Process Improvement <input type="checkbox"/><br>Human Factors <input type="checkbox"/> |                                                                                                         | FAULT CATEGORY                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                  |
|                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                         | Pressure/Forced <input type="checkbox"/><br>Bending <input type="checkbox"/><br>Crushing <input type="checkbox"/><br>Cracks <input type="checkbox"/><br>Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/><br>Marks/Chatter <input type="checkbox"/><br>Mislabeled <input type="checkbox"/><br>Other/Details: _____ | Contamination <input type="checkbox"/><br>Misaligned/off center <input type="checkbox"/><br>BOM/Route <input type="checkbox"/><br>Broken/Damage/Defect <input type="checkbox"/><br>Incomplete/Unclear Instructions <input type="checkbox"/><br>Drill Holes <input type="checkbox"/><br>Fit/Function <input type="checkbox"/> | Power Loss/Surge <input type="checkbox"/><br>Folio/Program <input type="checkbox"/><br>Grain Direction <input type="checkbox"/><br>Weld <input type="checkbox"/><br>Wrong Stock Pulled <input type="checkbox"/><br>Out of Sequence <input type="checkbox"/><br>Off-set/Set-up <input type="checkbox"/> | Positioned Wrong <input type="checkbox"/><br>Outside Tolerance <input type="checkbox"/><br>Drawing <input type="checkbox"/><br>Finish <input type="checkbox"/><br>Part Lost/Missing <input type="checkbox"/><br>Misread <input type="checkbox"/> |
| Completed By _____                                                                                                                                                                                                                                                                                                                                                           |                                                                                                         | Lead hand / Supervisor _____                                                                                                                                                                                                                                                                                           |                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                  |
| QC / QA Coordinator _____                                                                                                                                                                                                                                                                                                                                                    |                                                                                                         |                                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                  |